

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016948**Date Inspected:** 07-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006605

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

LIFT-5 SOUTH TOWER GRILLAGE

SSD1 – TL5 – 1E/F – 1B

SSD1 – TL5 – 1E/F – 5B; 6A/B; 10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 09 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 037932. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by

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QC appeared to comply with the WPS – B – T – 3213 – TC –U4c.

Weld joint # 07 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 066002. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC –U4c.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Submerged Arc Welding (SAW):

Weld joint # 01 located on SEG3007AC (BP3032+BP3033). Welder is identified as 044780. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 14 located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4c.

Weld joint # 03 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 066763. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4c.

Weld joint # 17 located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4c.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 13 located on Bottom plate BP3093 – 001. Welder is identified as 049220. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132. (See attached photo)

Weld joint # 24 located on Bottom plate BP3093 – 001. Welder is identified as 040759. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer